

Work Order ID 51980

September 11, 2009 9:50:45 AM



Page 1

Item ID: D3822-1KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Vertical Tunnel, LH-Grey

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *RL*

Date: *09-9-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

Y111807
BB 09/05/09
X2

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA025 using tool DT9073
Dwg Rev: *C*
Folio Rev: *A*

BB 09/15/09
X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

DART AEROSPACE LTD	Work Order: 51980
ENGINEERING	
Description: Panel, without Rotor Brake	Part Number: D3821-1KIV/KGY
Inspection Dwg: D3821	Rev: B
	Page 1 of 1

WORK ORDER
NO. 51980

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *BB*

Date: 09/16/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	Min					
0.75	Min					
0.63	Min					
0.25	Min					
0.375	Min					

Measured by:

Date:

Audited by:

Date:

Prototype Approval:

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 51980.
Description: TUNNEL LH		Part Number: D3822-1 K4Y
Inspection Dwg: 3822	Rev: ✓	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/16/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.3	REF	39.3	✓			
8.6	REF	8.7	✓			
.3	Min	.39	✓			
.55	Min	.74	✓			
.8	Min	1.02	✓			
.040	Min	.052	✓			
.030		.041				

Measured by: BB

Date: 09/16/09

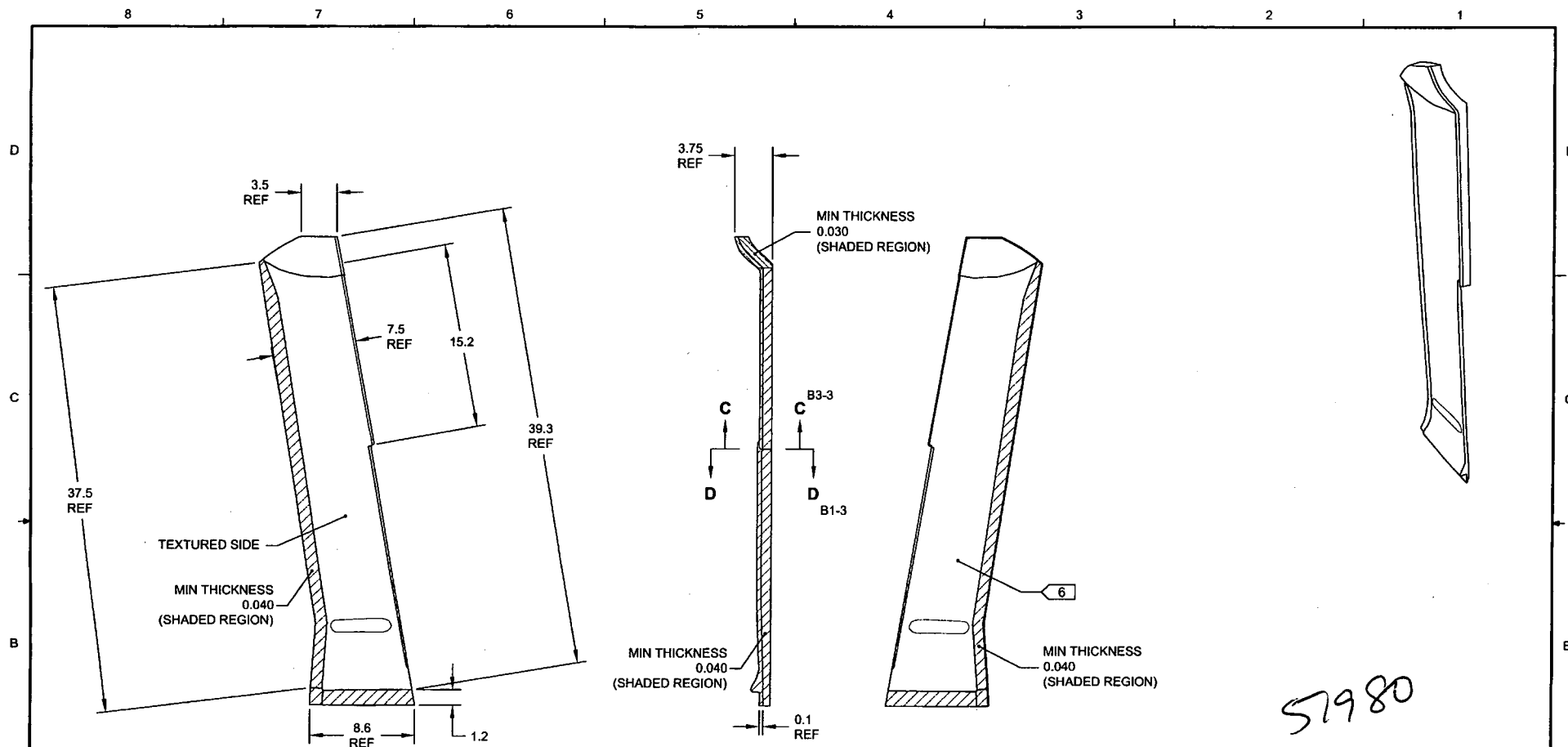
Audited by: WJ

Date: 09/16/09

Prototype Approval: _____

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3822-2 VERTICAL TUNNEL, RH
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9074 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

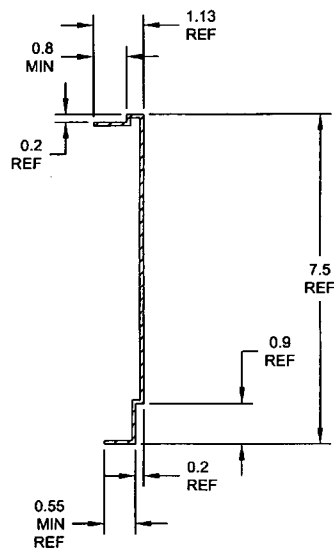


PART NUMBER	DESCRIPTION
D3822-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

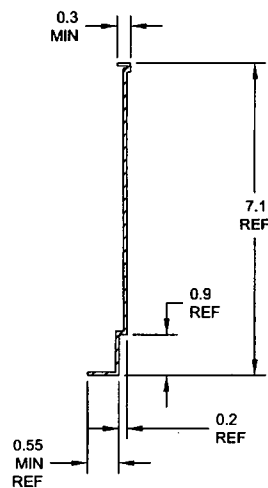
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DRAWN	REV. A	
CHECKED	REV. A	
MFG. APPR.	REV. A	
APPROVED	REV. A	
DE APPR.	REV. A	
DATE	09.05.05	

57980

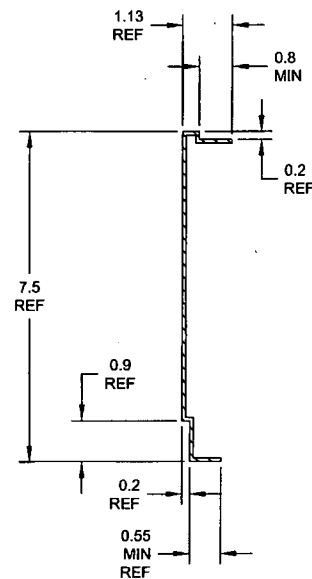
RELEASED
09/10/2012



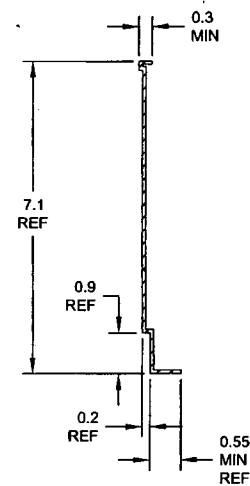
SECTION A-A C6-1



SECTION B-B C6-1



SECTION C-C C4-2



SECTION D-D C4-2

51980

RELEASED
09/09/02

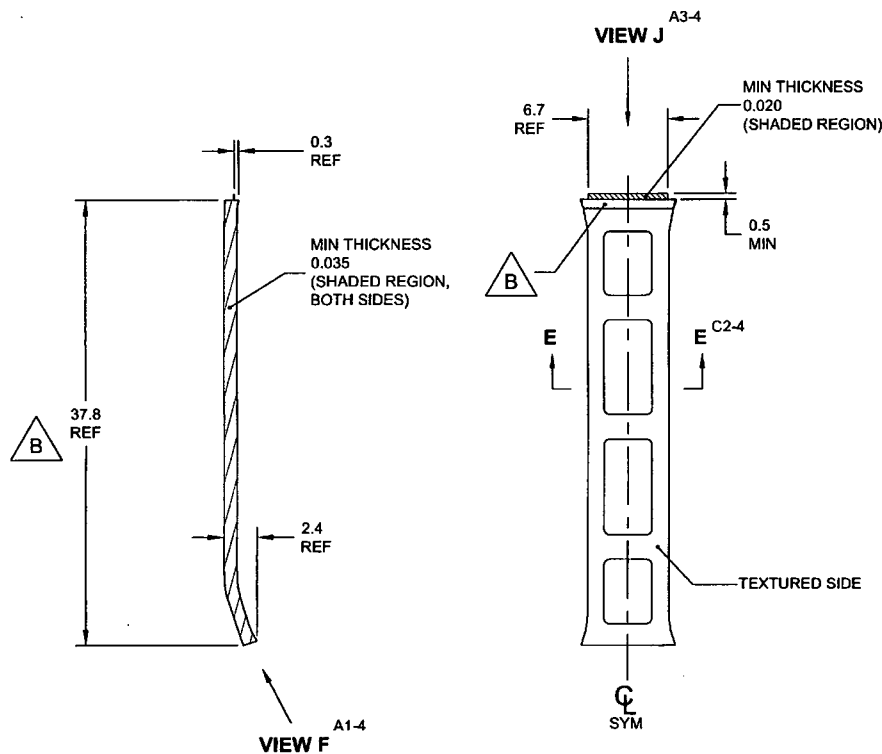
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CHECKED		DRAWING NO.	REV. C
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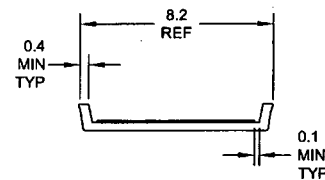
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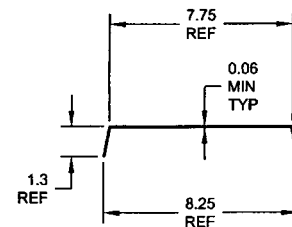
B



D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)



VIEW J
SCALE 2X



VIEW F
SCALE 2X
(ROTATED 90° CW)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

C
C

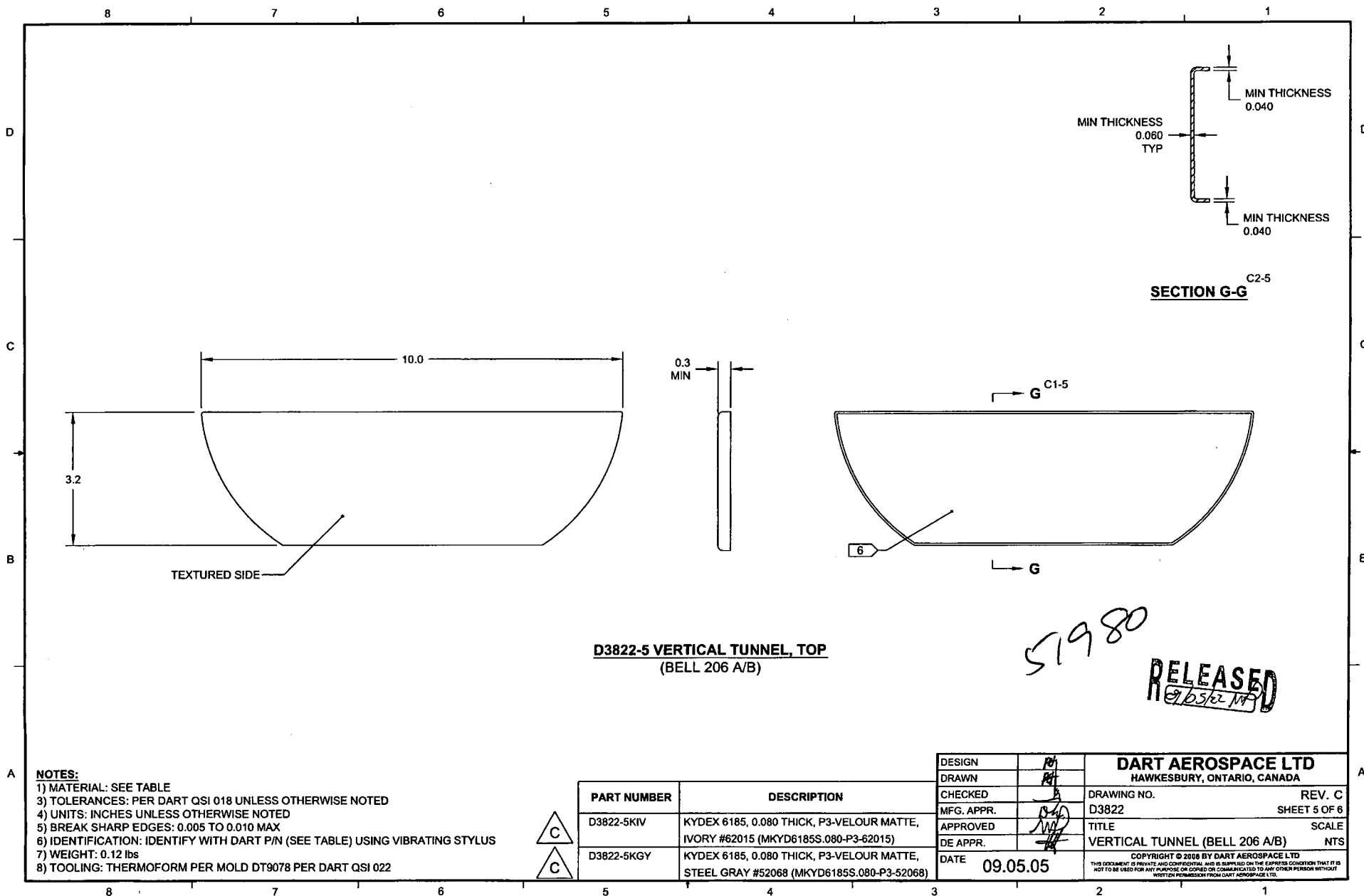
PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	DATE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	09.05.05	DRAWING NO.	REV. C
CHECKED		D3822	SHEET 4 OF 6
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MIN THICKNESS
0.040MIN THICKNESS
0.0400.20
0.15

2.0

0.4
REF0.3
REF5.9
H17.00
MIN

TEXTURED SIDE

H B1-6

0.3
REF

SECTION H-H B3-6

D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

51980

RELEASED
09/05/22**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

C

C

PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

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CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3822 SHEET 6 OF 6
APPROVED		TITLE SCALE
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